



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
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D5770-9

Job Sheet 208153

Part No: D5770-9

Part Name: Bushing



Part Weight: 0 lbs

Job Created: 3/12/20

Due Date: 3/23/20

Type: Stock

Note: URF 20-522 DWG 5770 REV.A IPP REV.A NEW ISSUE 20.01.14 JV VERF:DD

Ship Via:

Job Qty: 12 pcs

POSITIVE RECALL

EFFECTIVE 20/3/12 AUTH S.M.

RELEASED 9 DATE 20-4-20

Status: New

9-89

Priority: Medium

Job Tracking No:

Created By: Jennifer Renwick

Description:

## Bill of Materials

## Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier	Sign-off
						Workcenter / Supplier Lead Time	
100	SL-154 - 1	12 pcs	3/23/20	0.50	0.45	SL-154 - 1	
110	QC 2	12 pcs	3/23/20	0.00	0.00	QC 2 - 1	SL 20-3-21
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	SL
						QC 2 - 32	
						QC 2 - 33	
						QC 2 - 35	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 86	
						QC 2 - 84	

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Container No: S265462

Part: D5770-9

Job No: 208153

Serial No/Batch: S265462

Revision: REV.A

Inspector:

Exp Date:

Instructions:

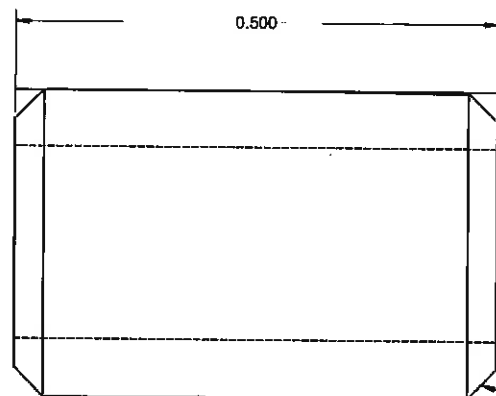
Date: 03/21/20

Plex 3/12/20 8:58 AM Dart.Renwick.Jennifer

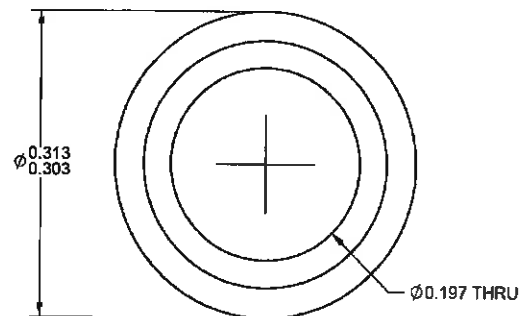
[illegible]

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	12 pcs	3/23/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
<p>Part Op 100 - *****DO NOT DO ANY CHAMFER ON THE OUT SIDE OF THE BUSHING***** 1-Machine as per folio</p> <p>Descriptions: FD197 FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2-Debut</p> <p>110 - QC2- Inspect parts off machine FA/FAIB</p> <p>120 - QC2- inspect parts - second check</p> <p>130 - identify as per dwg &amp; Stock Location: <u>          </u> See nota 3.</p> <p>140 - QC21- Final Inspection/ - Work Order Release</p>					
<b>Job BOM</b>					
Part / Item	Component Name	Quantity	Operation	Container	
M4130NR0.313	4130 Steel Round Bar .313"	.6396 ft (.0533 ea)	100-SL-154 - 1	S055287-24	
<b>Job Allocations</b>					
Operation	Component Part	Required	Inventory	Allocated	
100-SL-154 - 1	M4130NR0.313	1	23	0	
<b>Part Specifications</b>					
Specifications could not be found.					

Plex 3/12/20 8:56 AM Dart.Renwick.Jennifer



0.03 X 45°  
MAX  
2 PL



**D5770-8 BUSHING**  
(DERIVED FROM AERO DESIGN P/N 84272-01)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 208153

UNDER REVIEW  
URF 2020-522 20.02.14 (NO)

**NOTES:**

- 1) MATERIAL: AISI 4130N ROUND BAR  
PER MIL-S-6758 OR AMS 6348/6370/6528  
REF DART SPEC M4130N-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 0.01 lbs

**RELEASED**  
2020 FEB 18 *NO*

APPROVED

DESIGN	ZF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	KPT	DRAWING NO. <b>D5770</b>	REV. A
MFG. APPR.	DD	TITLE <b>BASKET HOOPS</b>	SHEET 7 OF 7
APPROVED	NO		SCALE
DE APPR.	CP		NTS
DATE	20.01.09	COPYRIGHT © 2020 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

Job: _____  Part No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	<b>DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Water Jet <input type="checkbox"/>            Supplier <input type="checkbox"/>            Quality <input type="checkbox"/> </div> </div>		
Date :	Sequence #:	QTY Affected :		MRB (QSI042)
Description Work Order Deviation		Disposition		Completed By _____  Lead hand / Supervisor _____  QC / QA Coordinator _____
<b>Root Cause</b>  Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Presservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/>		<b>FAULT CATEGORY</b>  <div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Pressure/Forced  <input type="checkbox"/> Bending  <input type="checkbox"/> Crushing  <input type="checkbox"/> Cracks  <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist  <input type="checkbox"/> Marks/Chatter  <input type="checkbox"/> Mislabeled         </div> <div> <input type="checkbox"/> Contamination  <input type="checkbox"/> Misaligned/off center  <input type="checkbox"/> BOM/Route  <input type="checkbox"/> Broken/Damage/Defect  <input type="checkbox"/> Incomplete/Unclear Instructions  <input type="checkbox"/> Drill Holes  <input type="checkbox"/> Fit/Function         </div> <div> <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Folio/Program  <input type="checkbox"/> Grain Direction  <input type="checkbox"/> Weld  <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Off-set/Set-up         </div> <div> <input type="checkbox"/> Positioned Wrong  <input type="checkbox"/> Outside Tolerance  <input type="checkbox"/> Drawing  <input type="checkbox"/> Finish  <input type="checkbox"/> Part Lost/Missing  <input type="checkbox"/> Misread         </div> </div>		
		Other/Details:		